

Order ID 53046

October 22, 2009 11:26:58 AM



Page 1

Item ID: D3849-045
 Revision ID: B
 Item Name: AFT WEARPLATE ASSY, FLOAT GEAR

Accept



Setup Start



Stop



Start Date: 21/10/2009 Start Qty: 2.00
 Required Date: 30/10/2009 Req'd Qty: 2.00



Cust Item ID:
 Customer:

Reference:

Run Start



Approvals: Process Plan: *RP* Date: *09-10-27* Tooling: Date:
 QC: Date: SPC (Y/N): Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr.	Revision Nbr
D3849	B

SCRAP

100
 Waterjet
 FLOW CNC Waterjet

Memo
 1-Cut as per Dwg D3849
 Dwg Rev: *B*
 Prog Rev: *B*
 2-Deburr if necessary

0.00

QC2- Inspect parts off machine FAI/FAIB

0.00

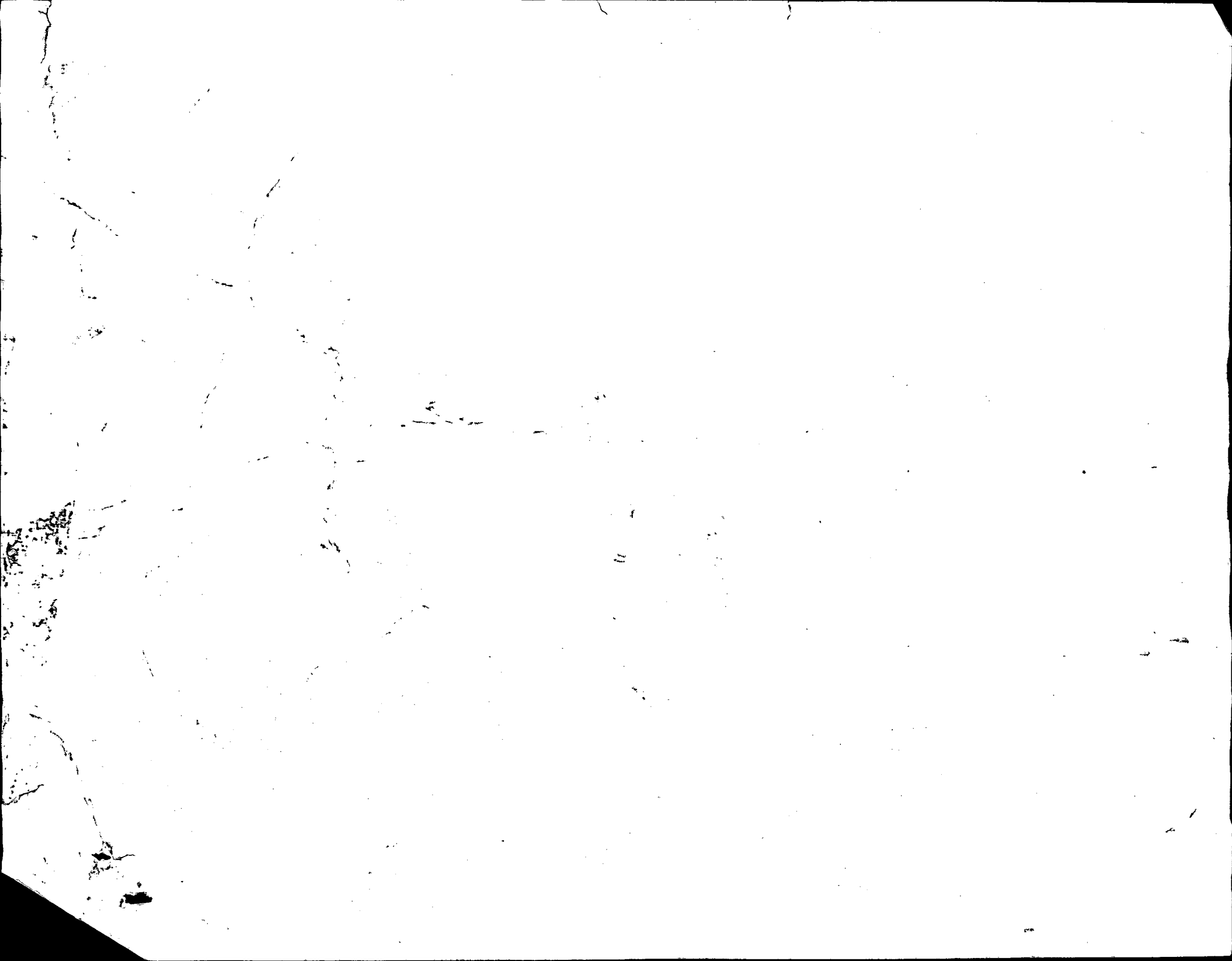
Memo

110
 QC
 Quality Control

FB 9-10-26

FB 9-10-26

(4)



Work Order ID 53046

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Page 2

Item ID: D3849-045
Revision ID: B
Item Name: AFT WEARPLATE ASSY, FLOAT GEAR
Start Date: 21/10/2009 Start Qty: 2.00
Required Date: 30/10/2009 Req'd Qty: 2.00
Reference:

Accept



Setup Start



Stop



Cust Item ID:
Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	2> 801/10/27				1		
130 Brake NC Brake NC	Form as per Dwg Memo	0.00 0.00	SB 09/11/02			4	0		
140 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				4			

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Setup Start



Stop



Start Date: 21/10/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 30/10/2009 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 		0.00							
Large Fab	Memo	0.00							
Large Fab	1-On D3901-5 bar, fill cut outs with hard coat welding rod as per Dwg 2059b Hardcoat rod Batch: <u>M112963</u> 2-Weld D3901-5 Bar to wearplate by positioning holes together as per Dwg 304ss Welding Rod Batch: <u>M102421</u>								
160 	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC Quality Control	Memo	0.00							
170 	QC5- Inspect part completeness to step on W/O	0.00							
QC Quality Control	Memo	0.00							

Work Order ID 53046

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October 22, 2009 11:26:58 AM

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Setup Start



Stop



Start Date: 21/10/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 30/10/2009 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 Memo	0.00 0.00							
190 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							
200 Small Fab Small Fab	 Memo I-Bond D3848-5 gasket to inner surface of wearplate using a thin layer of 3m 1300/1300L Scotch grip adhesive Batch: _____	0.00 0.00							

Work Order ID 53046

October 22, 2009 11:26:58 AM



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Item ID: D3849-045
Revision ID: B
Item Name: AFT WEARPLATE ASSY, FLOAT GEAR

Accept



Setup Start



Stop



Start Date: 21/10/2009 Start Qty: 2.00

Required Date: 30/10/2009 Req'd Qty: 2.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210 	QC5- Inspect part completeness to step on W/O	0.00							
QC Quality Control	Memo	0.00							
220 	Identify as per dwg & Stock Location: _____	0.00							
Packaging Packaging	Memo	0.00							
230 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

Picklist Print

Page 1

October 22, 2009 11:27:02 AM

Work Order ID: 53046



Parent Item: D3849-045RevB



Parent Item Name: AFT WEARPLATE ASSY, FLOAT GEAR

Start Date: 21/10/2009

Required Date: 30/10/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3848-5RevB		Manufactured	No				Each	8.0000	2.0000			
GASKET												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

FP

6

51840

6

Main Warehouse

ST

2

47815

2

D3901-5RevB

Manufactured No

Each

2.0000

2.0000



Bar

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

2

51838

2

Picklist Print

Page 2

October 22, 2009 11:27:02 AM

Work Order ID: 53046



Parent Item: D3849-045RevB



Parent Item Name: AFT WEARPLATE ASSY, FLOAT GEAR

Start Date: 21/10/2009

Required Date: 30/10/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S18GA		Purchased	No				sf	197.0169	7.6000	15.2000		
304/316 .050 Sheet												

189-10-26

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	197.0169053	
108156	0.98526316	
111743	23.7174	
112178	44.3142421	
112885	128	

112885

DART AEROSPACE LTD		Work Order:	53046
Description: Wearplate		Part Number:	D3849-5
Inspection Dwg: D3849 Rev: B		Page 1 of 1	

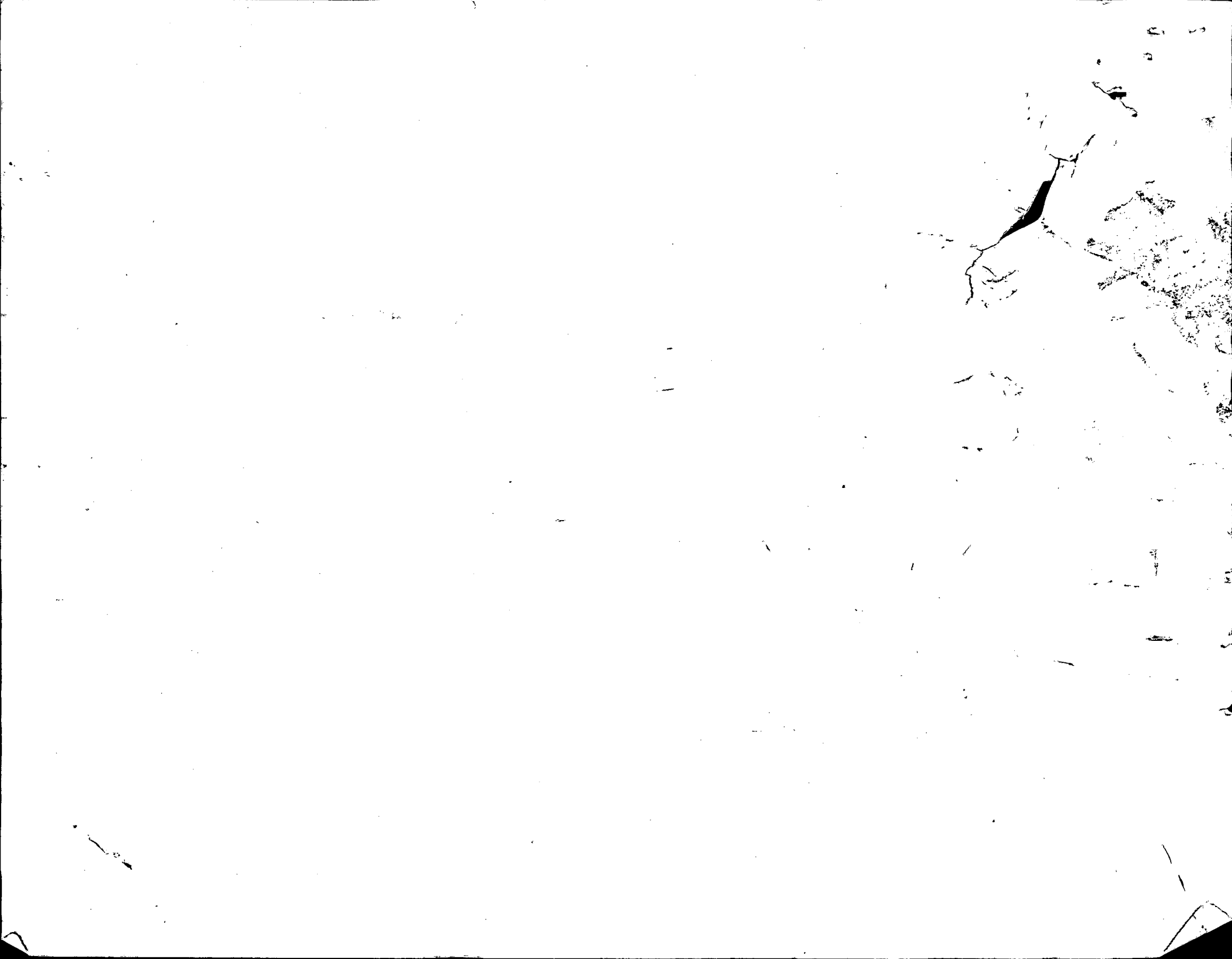
FIRST ARTICLE INSPECTION CHECKLIST

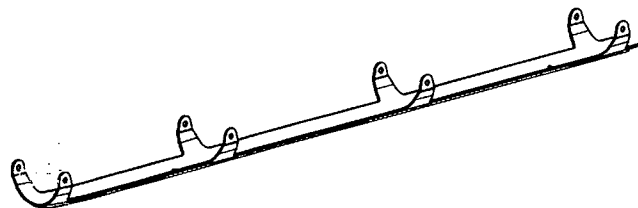
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.188	+0.005/-0.001	.193	*			
Ø0.375	+0.006/-0.001	.376	*			
0.125	+/-0.010	.129	*			
0.88	+/-0.030	.881	*			
0.75	+/-0.030	.756	*			
3.283	+/-0.010	3.281	*			
2.433	+/-0.010	2.428	*			
6.642	+/-0.010	6.640	*			
7.72	+/-0.030	7.714	*			
2.45	+/-0.030	2.45	*			
4.00	+/-0.030	4.001	*			
18.712	+/-0.010	18.712	*			
36.622	+/-0.010	36.622	*			
62.788	+/-0.010	62.788	*			
75.261	+/-0.010	75.261	*			
4.38	+/-0.030	4.378	*			
7.00	+/-0.030	7.00	*			
51.00	+/-0.030	51.00	*			
79.76	+/-0.030	79.75	*			
0.050	+/-0.010	.049	*			

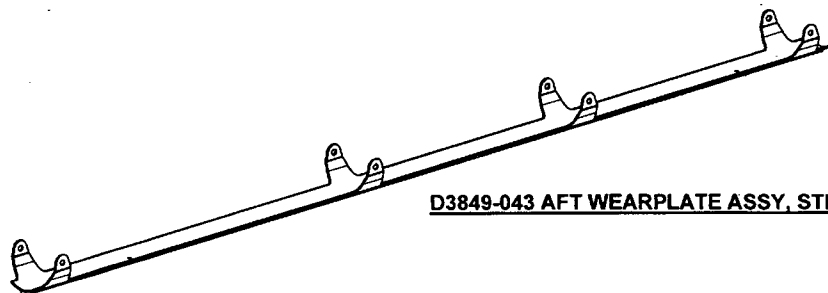
Measured by: <u>IB</u>	Audited by: <u>S</u>	Prototype Approval:	N/A
Date: <u>9-10-24</u>	Date: <u>09/10/24</u>	Date:	N/A

Rev	Date	Change	P/O D3849-045	Revised by	Approved
A	09.09	New Issue		KJ	<u>[Signature]</u>

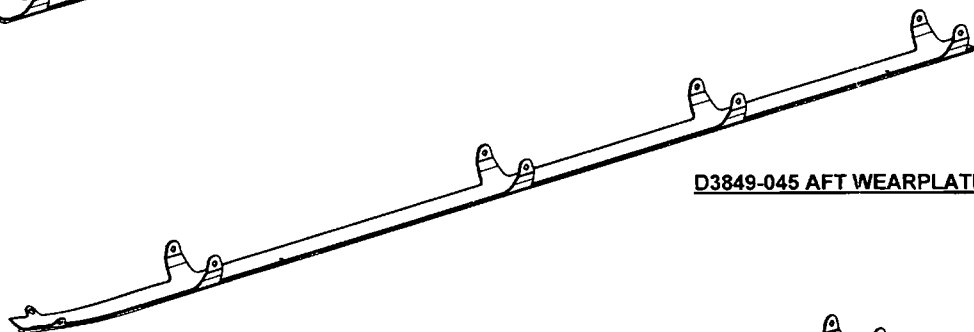




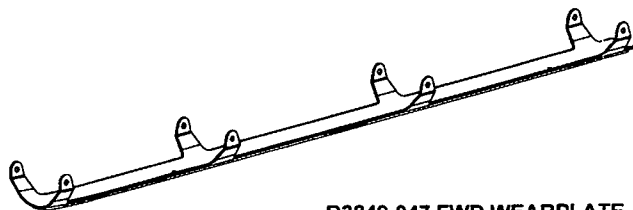
D3849-041 FWD WEARPLATE ASSY, STD GEAR



D3849-043 AFT WEARPLATE ASSY, STD GEAR



D3849-045 AFT WEARPLATE ASSY, FLOAT GEAR



D3849-047 FWD WEARPLATE ASSY, FLOAT GEAR

ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
1	X				D3849-041	FWD WEARPLATE ASSY, STD GEAR
2		X			D3849-043	AFT WEARPLATE ASSY, STD GEAR
3			X		D3849-045	AFT WEARPLATE ASSY, FLOAT GEAR
4				X	D3849-047	FWD WEARPLATE ASSY, FLOAT GEAR
11	1				D3849-1	PLATE
12		1			D3849-3	PLATE
13			1		D3849-5	PLATE
14				1	D3849-7	PLATE
15	1				D3848-1	GASKET
16		1			D3848-3	GASKET
17			1		D3848-5	GASKET
18				1	D3848-7	GASKET
19	1			1	D3901-1	BAR
20		1			D3901-3	BAR
21			1		D3901-5	BAR
31	A/R	A/R	A/R	A/R	2059B	HARDCOAT
32	A/R	A/R	A/R	A/R	1300 (OR 1300L)	3M SCOTCH-GRIP ADHESIVE

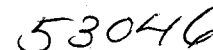
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 53046

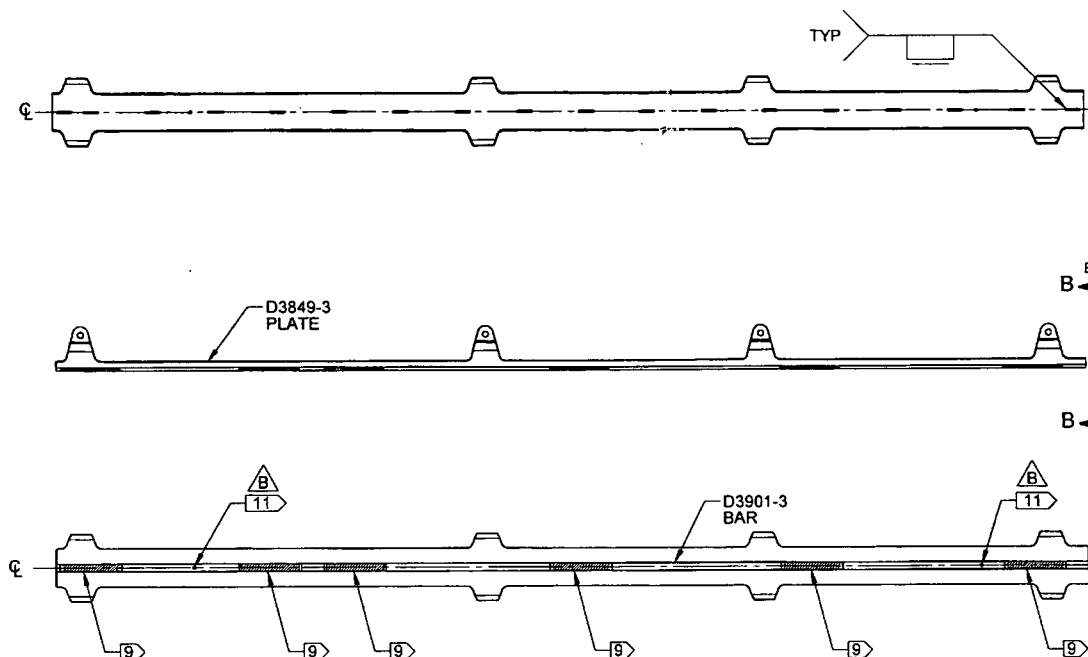
1009-10-22

RELEASED
09/07/15

B	REVISED FLAT PATTERN Ø0.375 WAS SLOT HOLE ON D3849-1F/-3F/-5F (ZN A4-5, B4-7, B4-8, C2-10, B2-10); ADD D3849-047 (ZN D4-1, A4-1 & B4-5) & D3849-7/-7F (ZN C4-9, A4-9); ADD SECTION K-K (ZN C5-10); 0.88 WAS 0.875 & 0.44 WAS 0.438 (ZN A3-10); ADD 0.25 & 0.88 (ZN D4-10, D3-10); ADD 0.88 & 0.44 (ZN C3-10 & B3-10); ADD FLAG NOTE (ZN A8-2, C6-2, C3-2, A8-3, C6-3, C3-3, A8-4, C6-4, C2-4); 66.87 WAS 67.36 (ZN B4-7)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	GO	D3849	SHEET 1 OF 10
APPROVED	MM	TITLE	SCALE
DE APPR.	H	WEARPLATE ASSY	NTS
DATE	09.06.30	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



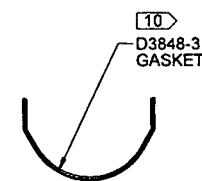
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DRAWN	RF	PORT HADLOCK, WA	
CHECKED	<i>RF</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>RF</i>	D3849	SHEET 2 OF 10
APPROVED	<i>RF</i>	TITLE	SCALE
DE APPR.	<i>RF</i>	WEARPLATE ASSY	NTS
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53046

D3849-043 AFT WEARPLATE ASSY, STD GEAR

SECTION B-B C2-3
SCALE 2X

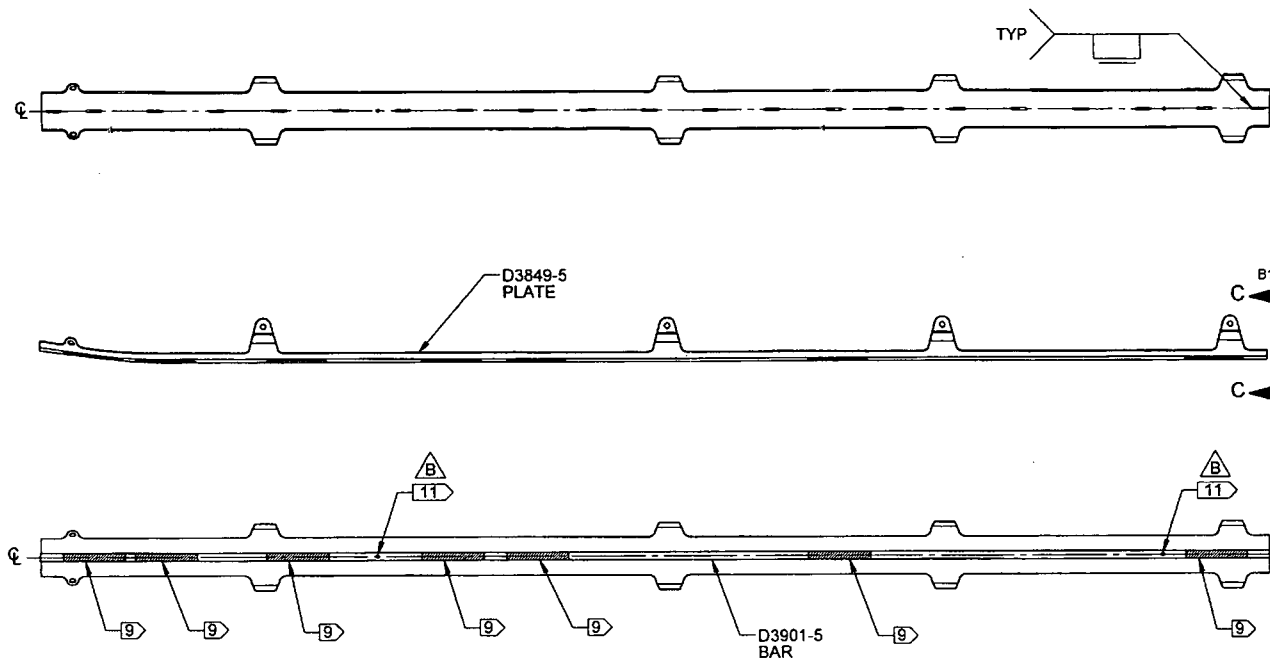


NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3849-043" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3849-043 = 5.21 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK x 0.50 WIDE, FLUSH WITH D3901-3 BAR ON ALL 3 SURFACES
- 10) AFTER FINISH, BOND D3848-3 GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE
- 11) TRANSFER DRILL \varnothing 0.188 HOLES FROM D3849-3 PLATE TO D3901-3 BAR

DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. D3849	REV. B
MFG. APPR.	RF	TITLE WEARPLATE ASSY	SHEET 3 OF 10
APPROVED	RF	SCALE	NTS
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DATE	09.06.30		

RELEASED
10/07/15



D3849-045 AFT WEARPLATE ASSY, FLOAT GEAR

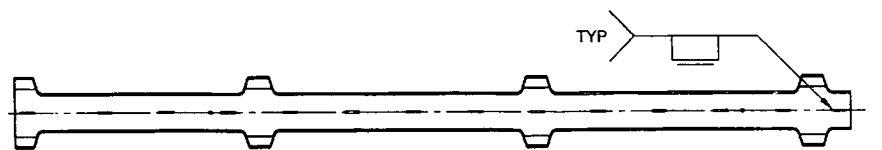
SECTION C-C C2-4
SCALE 2X

RELEASED
09/15/15

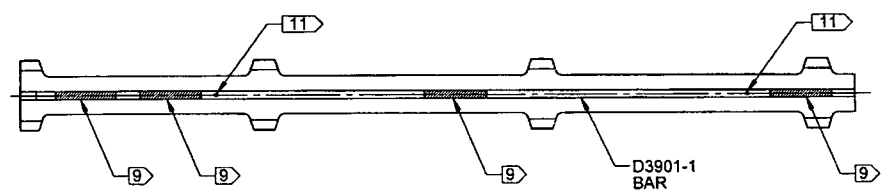
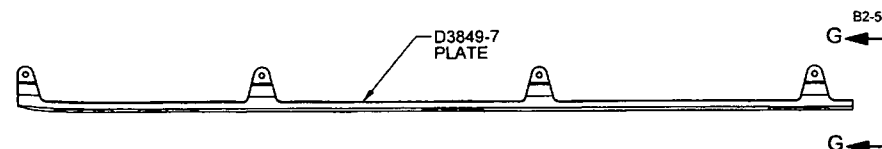
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDEXT" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3849-045" USING YELLOW PAINT MARKER AT INSIDE SURFACE
- 7) WEIGHT: D3849-045 = 5.98 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK x 0.50 WIDE, FLUSH WITH D3849-5 BAR ON ALL 3 SURFACES
- 10) AFTER FINISH, BOND D3848-5 GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE
- 11) TRANSFER DRILL Ø0.188 HOLES FROM D3849-5 PLATE TO D3901-5 BAR

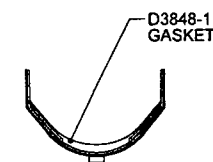
DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	PH	D3849	SHEET 4 OF 10
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARPLATE ASSY	NTS
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53646



D3849-047 FWD WEARPLATE ASSY, FLOAT GEAR



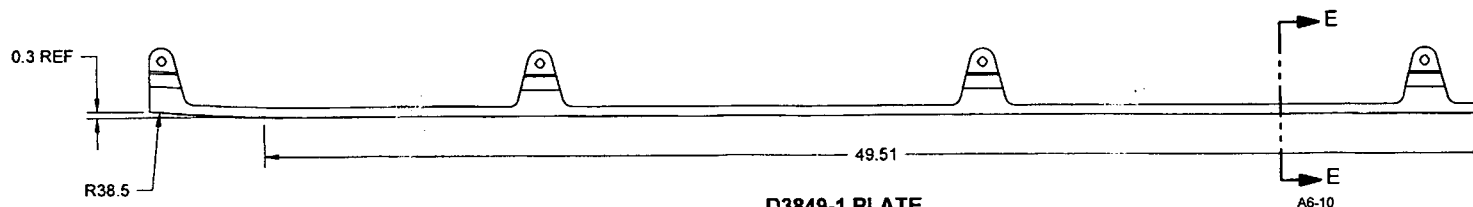
SECTION G-G C3-5
SCALE 2X

RELEASED
09/07/10

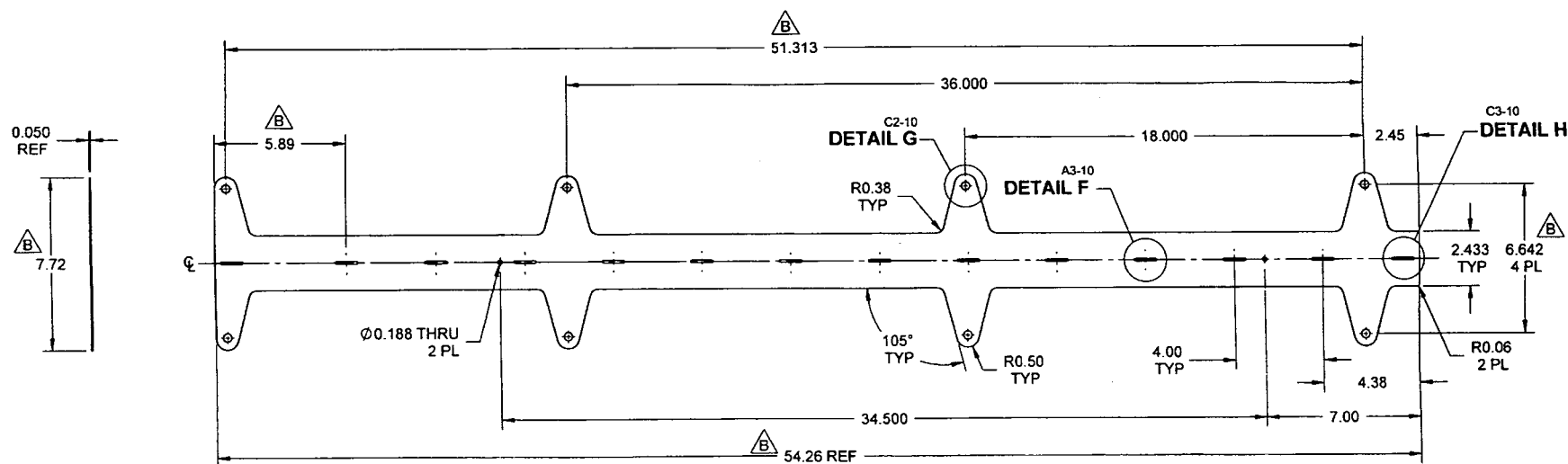
- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT "GREY SANDEXT" (4.3.5.6) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3849-047" USING YELLOW PAINT MARKER AT INSIDE SURFACE
 - 7) WEIGHT: D3849-047 = 4.26 lbs
 - 8) WELDING: PER QSI 004
 - 9) 2059B HARDCOAT WELD, 0.19 THICK x 0.50 WIDE, FLUSH WITH D3901-1 BAR ON ALL 3 SURFACES
 - 10) AFTER FINISH, BOND D3848-7 GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE
 - 11) TRANSFER DRILL $\varnothing 0.188$ HOLES FROM D3849-7 PLATE TO D3901-1 BAR

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3849	SHEET 5 OF 10
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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53046



D3849-1 PLATE
(MAKE FROM D3849-1F)



D3849-1F FLAT PATTERN

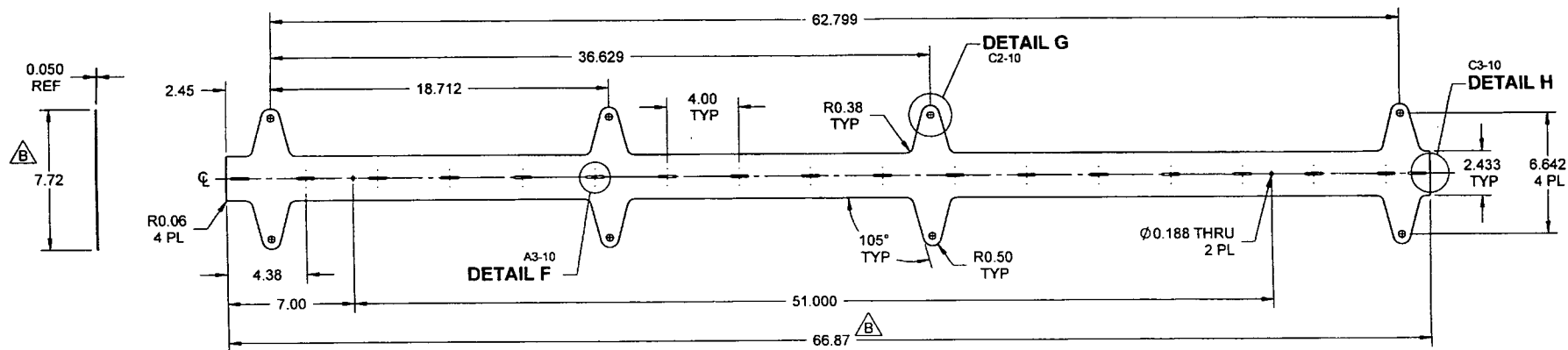
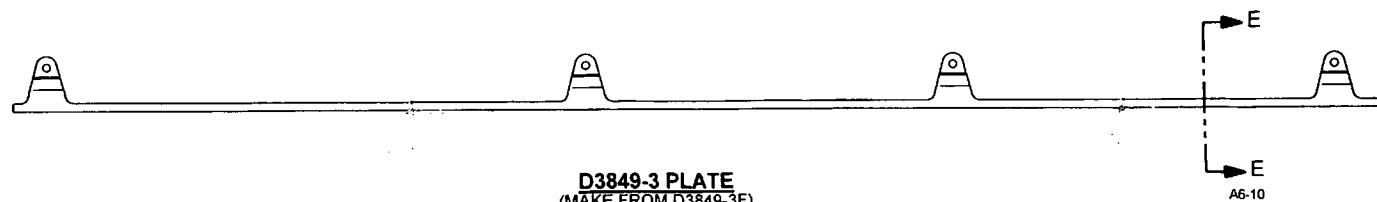
RELEASED
01/17/13

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE 0.050 THICK, (REF. DART SPEC. M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.33 lbs

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3849	SHEET 6 OF 10
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
DATE	09.06.30	<small>COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPILED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

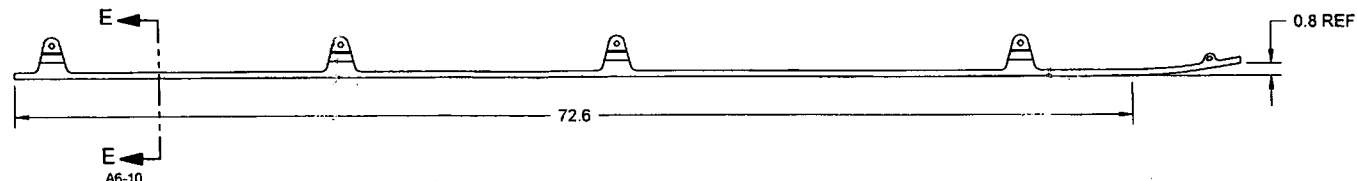
53046

**D3849-3F FLAT PATTERN** RELEASED
09/07/51**NOTES:**

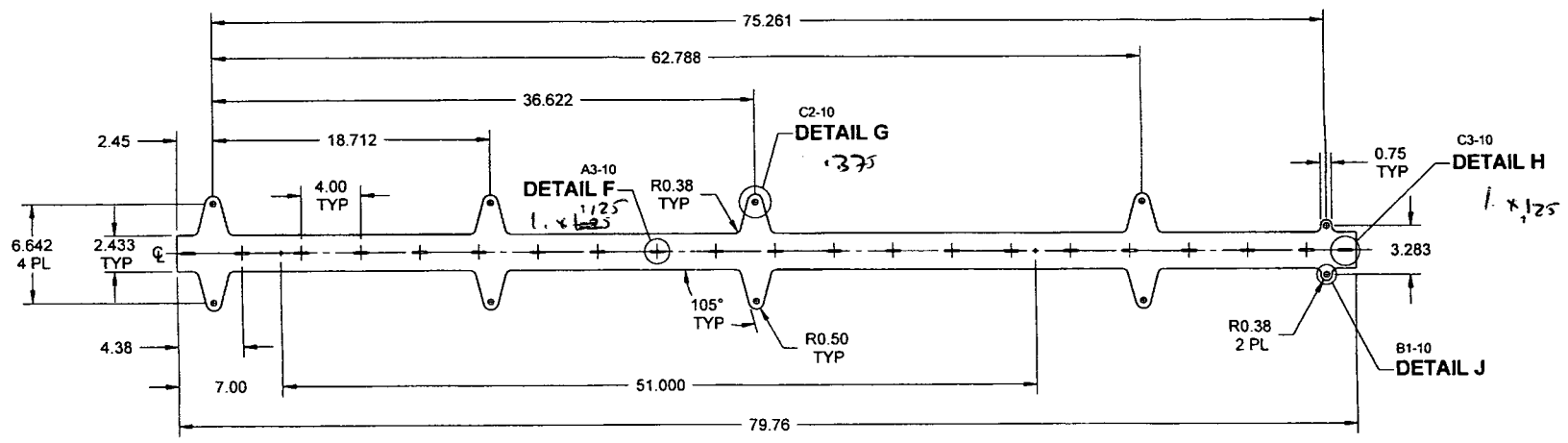
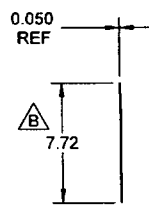
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE 0.050 THICK, (REF. DART SPEC. M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.82 lbs

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	<i>AK</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>ES</i>	D3849	SHEET 7 OF 10
APPROVED	<i>AK</i>	TITLE	SCALE
DE APPR.	<i>AK</i>	WEARPLATE ASSY	NTS
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53046



D3849-5 PLATE
(MAKE FROM D3849-5F)

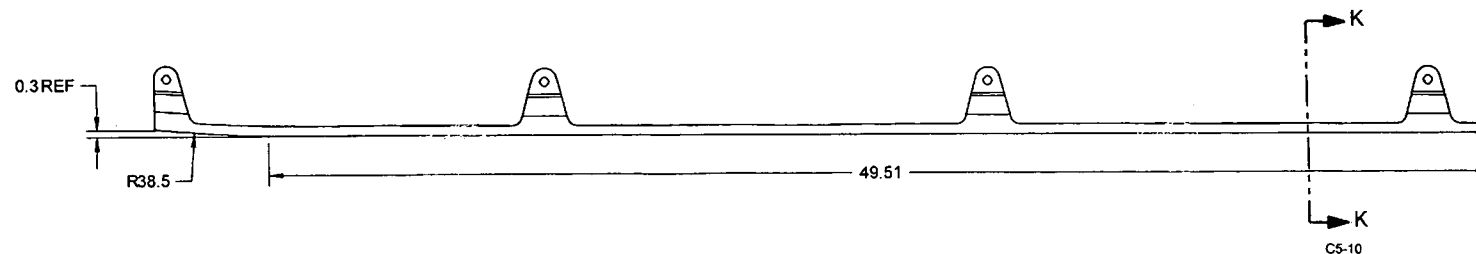


D3849-5F FLAT PATTERN

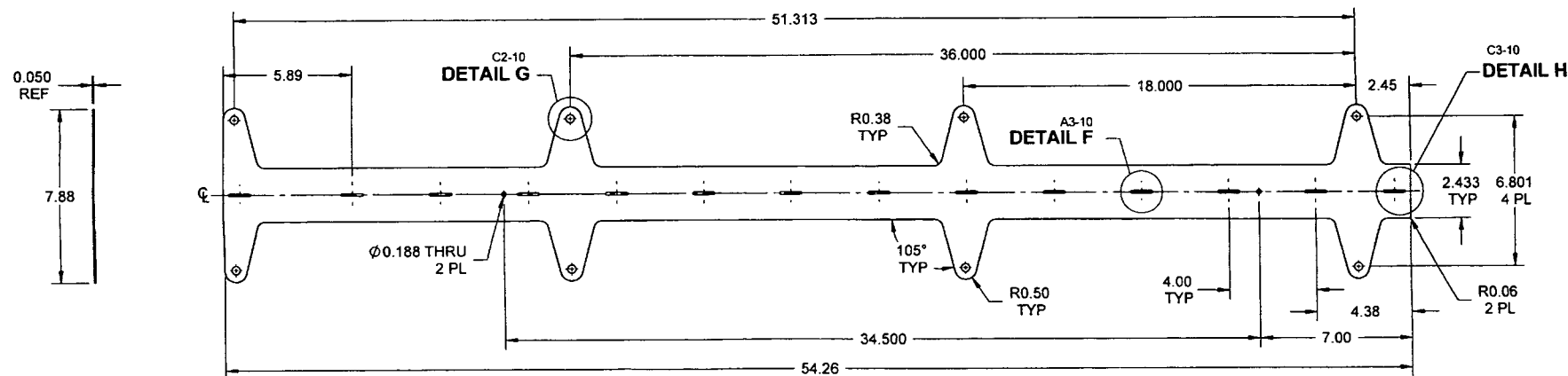
RELEASED
9/16/15

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524 18 GAUGE 0.050 THICK, (REF. DART SPEC. M304S18GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 3.30 lbs

DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3849	SHEET 8 OF 10
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	WEARPLATE ASSY	NTS
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D3849-7 PLATE
(MAKE FROM D3849-7F)



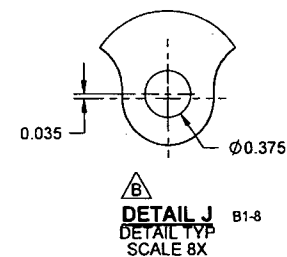
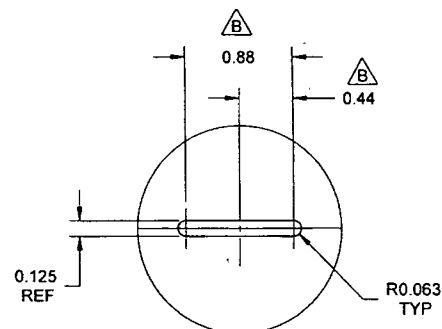
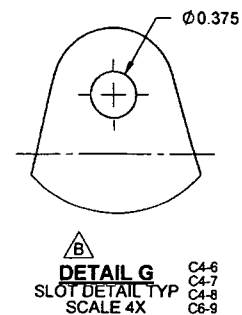
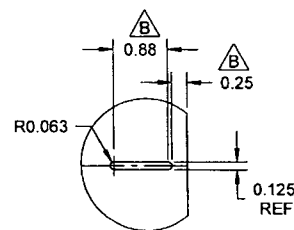
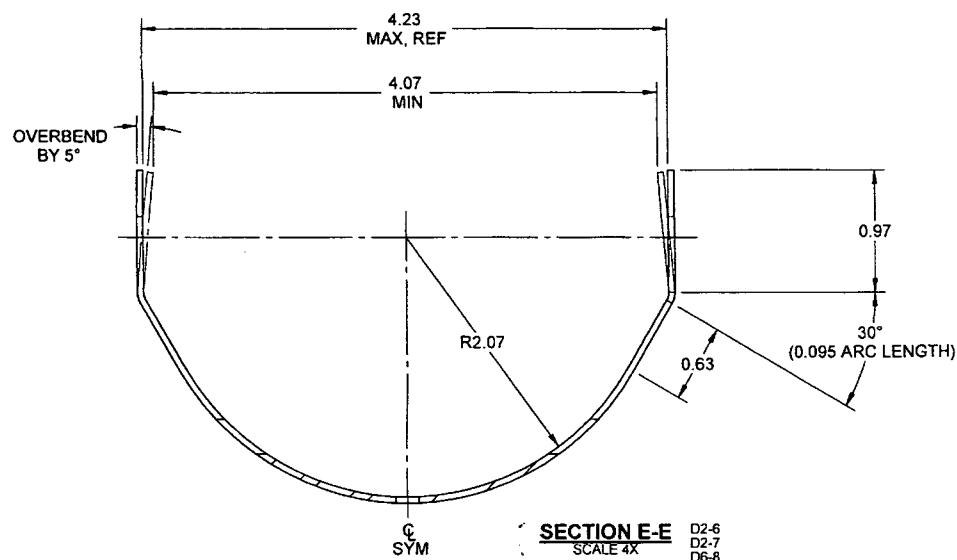
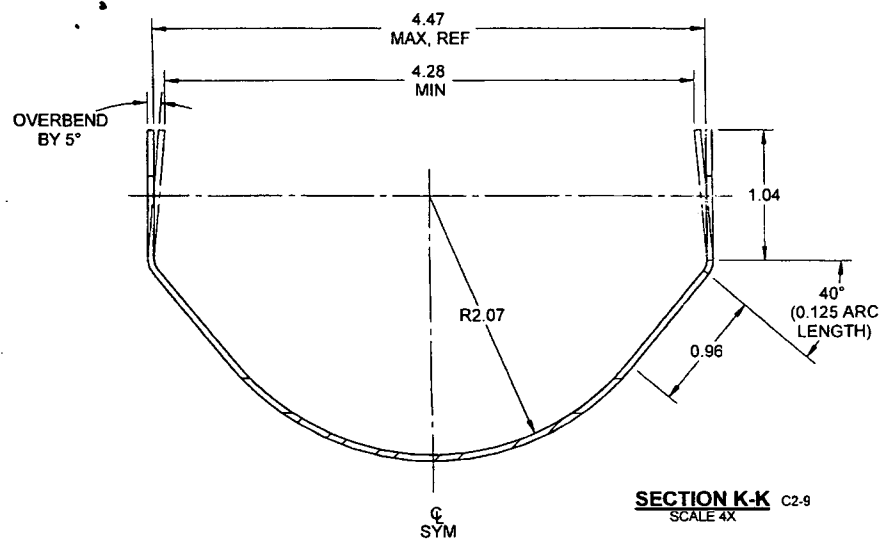
D3849-7F FLAT PATTERN

RELEASED
9/67/15M

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE 0.050 THICK, (REF. DART SPEC. M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.34 lbs

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3849	SHEET 9 OF 10
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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RELEASED
09/07/15

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3849	SHEET 10 OF 10
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	WEARPLATE ASSY	NTS
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